

Work Order ID 97912

97912

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March-01-13 1:50:21 PM

Item ID: D2942

D2942
B97912

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Window

Start Date: 3/01/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 3/12/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: MLC

Date: 13-03-04 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D2942 clean & wrap in plastic.								
110	QC5- Inspect part completeness to step on W/O	0.00	DAS						
110			27						
QC	Memo	0.00	9-89						
Quality Control									
120	Identify as per dwg & Stock Location: ST216	0.00							
120									
Packaging	Memo	0.00							
Packaging									

7 SAD 13-10-31

7

K-10-31

7X DAS 28 9-89 13-10-31

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending			Bend			Grain		Ovalized		Pressure/Forced	
Centre Not Concentric to O/S			BOM/Route			Hardware		Over/Under tolerance		Temperature/Cure	
Cracks			Broken/Damaged			Inspection Incomplete		Part Incorrect		Weld	
Crushed/Crimped.			Burrs			Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled	
Cuffs			Contamination			Maintenance		Part Moved			
Heat Treat			Countersink			Mislabeled		Positioned Wrong			
Inspection Strip in Tube			Cut Too Short			Misread		Power Loss/Surge			
Ripples in Bend			Drill Holes			Offset				Other	
Torque Waves in Extrusion			Drawing			Out of Calibration					
Turning Sequence			Finish			Out of Sequence					
Wave/Twist in Tube			Folio			Outside Dimensions					

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/>	
										<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <hr/> <hr/> <hr/>	
										<input type="checkbox"/> Other	

Picklist Print

March-01-13 1:50:20 PM

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Work Order ID: 97912

Parent Item: D2942

Parent Item Name: Replacement Window

Start Date: 3/01/13

Required Date: 3/12/13

Comments: IPP D01.06.05 New process EC
IPP E Thermoform in house 07.03.07 DL

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2126 Seal		Manufactured	No			100	f	337.6308	5.625	205	39.375	SAD	13-10-31
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST405			337.63079						
				57106			4						
				68336			2.44679						
				89058			331.184		① 102729		39.375		
D2956 Window Frame		Manufactured	No			100	Each	2.0000	1	1	4	SAD	13-10-31
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST213			2			90225			
				66565			1			94806			
				90225			1			97324			
D2958 Window		Manufactured	No			100	Each	3.0000	1	1	4	SAD	13-10-31
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST208			3						
				86092			1						
				91597			2			B106163	(7)		

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

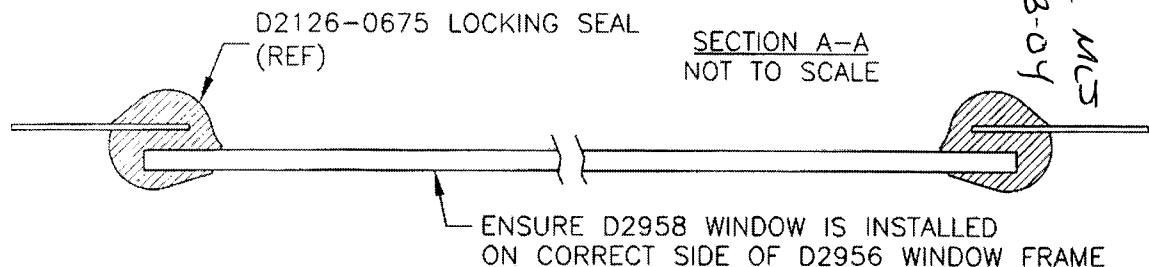
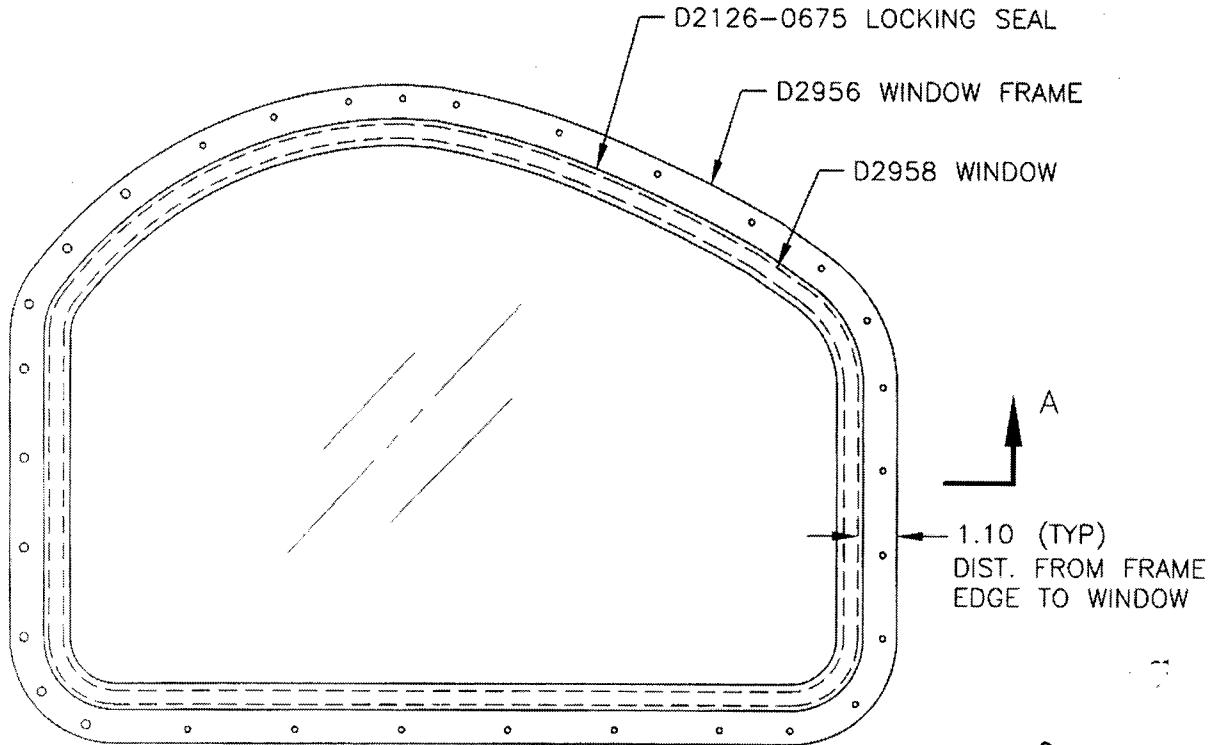
Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS							
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other						
Part No. _____		NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
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										<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <hr/> <hr/> <hr/>			
										<input type="checkbox"/> Other			

DART

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2942	SHEET 1 OF 1
DATE		TITLE	SCALE
01.05.31		REPLACEMENT WINDOW	1:5
A	00.01.20	NEW ISSUE	
B	00.02.23	CHANGED FROM RIVET TO SCREW; NOW SEALED ON EDGE ONLY (NCR 407)	
C	01.05.31	WINDOW NOW INSTALLED WITH SEAL	

RELEASED
01.06.05 AF



NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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